



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C3-8-3-1

Job Sheet 179132



Part No: C3-8-3-1

Job Qty: 30 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/14/18

Job Tracking No:

Due Date: 6/22/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3-8-2 Rev 3 IPP Rev A 18.04.09 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	30 Ea	6/22/18	6/22/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	30 pcs	6/22/18	6/22/18	0.08	2.50	Small Fab-9		MLL DAS 38
110	QC	30 pcs	6/22/18	6/22/18	0.00	0.00	QC5		38
130	Packaging	30 pcs	6/22/18	6/22/18	0.00	0.00	Packaging3-2		AUG 27 2018
140	QC21-SA	30 Ea	6/22/18	6/22/18	0.00	0.00	QC21		AUG 27 2018

Part Op 100 - 1-Using Epilog laser cut C3-8-3-1 as per DWG.
Descriptions: 130 - Identify and Stock

GA 9-89
DAS 21 9-89

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
46 8569K23	Teflon PTFE Plastic 0.020"	1.2900 sf (.043 ea)	90-Start up Operation	5036848

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	8569K23	1	6	0

Part Specifications

Specifications could not be found.

Plex 6/14/18 9:33 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

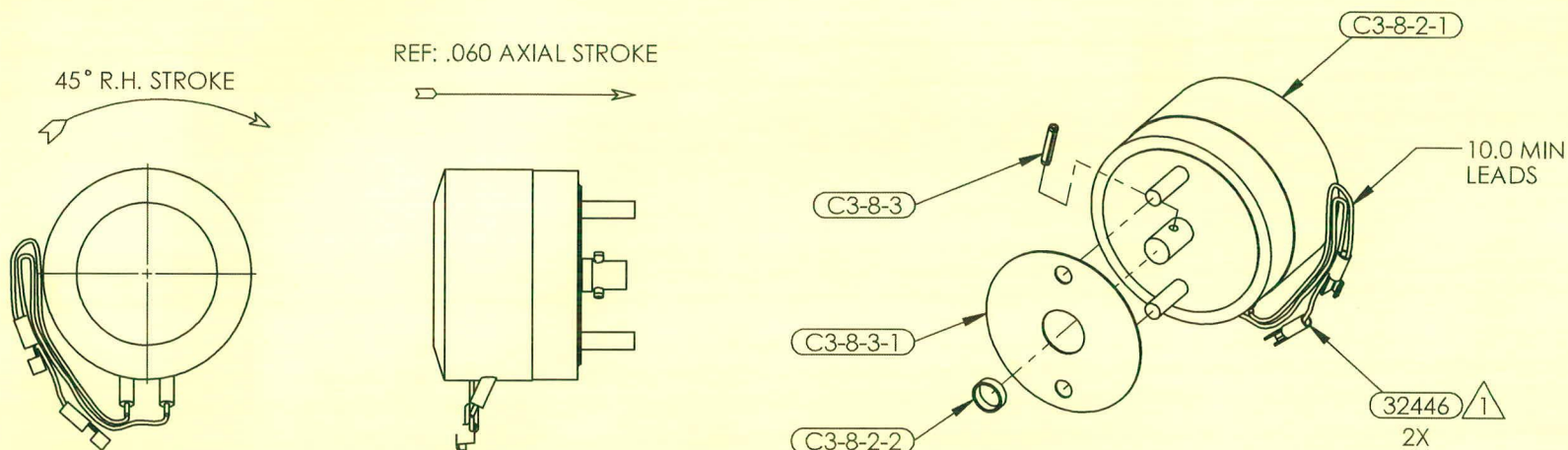
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																														
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				Lead hand / Supervisor Approval Verification																																																														
				QC / QA Coordinator Approval																																																														
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		ADDED SPACER C3-8-31.	10/10/2012	RJC	DW
1A	14-0111	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED ENGRAVE NOTE. ADDED NOTE $\triangle 1$.	8/7/2014	DJN	RW
2	14-0195	C3-8-2-1 CH'D DIM WAS LIMITS $\varnothing.0933-.0937$ IS LIMITS $\varnothing.094-.097$. ADDED "[CLOCKWISE]" TO NOTE $\triangle 3$. CH'D NOTE 4 WAS PLACE BUSHING AND PIN IN PLACE AS SHOWN AFTER DRILLING IS INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING. ADDED ENGRAVE BATCH NUMBER NOTE. C3-8-3-1 CH'D DIM WAS $\varnothing2.285$ IS $\varnothing1.95$. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	10/23/2014	DPD	JAG
3	15-0243	UPDATED TO NEW DRAFTING STANDARDS. C3-8-3-2 DELETED; REPLACED WITH 32446 .	8/25/2015	DPD	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 179132 MWS
18-06-14

NOTE:

$\triangle 1$ CONNECTIONS SUPPLIED LOOSE.

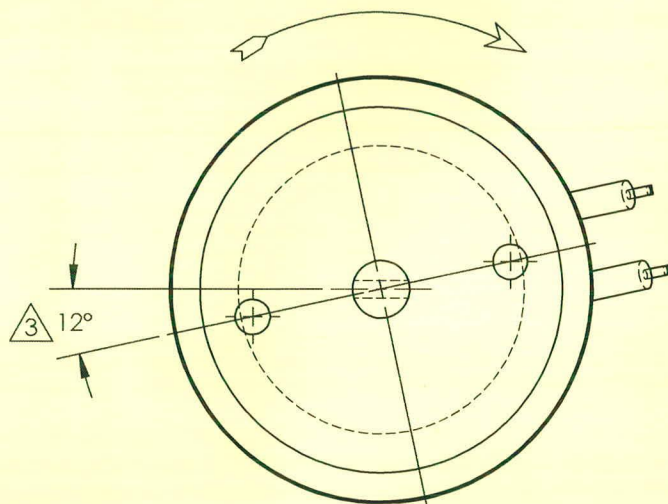
DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm .005$ FRACTIONS $\pm 1/8$.XX $\pm .01$ ANGLES $\pm 5^\circ$.X $\pm .1$	
DRAWN BY: CANAM APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2	DATE 12/19/2001
SHEET 1 OF 4	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
		B/O	C3-8-2-1	1	SOLENOID		TESTCO #152951-001	1,2
			C3-8-2-2	1	SOLENOID PIN SPACER	303 S.S.		3
		B/O	C3-8-3	1	SPRING PIN	18-8 S.S.	$\varnothing3/32$ X 1/2 (MCMASTER-CARR #92373A143)	1
		B/O	C3-8-3-1	1	SPACER	PETG		4
		B/O	32446	2	22-16 AWG KNIFE CONNECTOR		(ALLIED ELECTRONICS 32446)	1

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CAMBRIDGE, MASS.

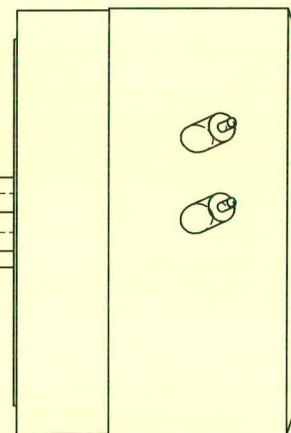
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	14-0195	C3-8-2-1 CH'D DIM WAS LIMITS $\varnothing.0933-.0937$ IS LIMITS $\varnothing.094-.097$. ADDED "(CLOCKWISE)" TO NOTE $\triangle 3$. CH'D NOTE 4 WAS PLACE BUSHING AND PIN IN PLACE AS SHOWN AFTER DRILLING IS INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING. ADDED ENGRAVE BATCH NUMBER NOTE.	10/23/2014	DPD	JAG



$\varnothing.097$
 $\varnothing.094$

.232



ENGRAVE
BATCH
NUMBER

NOTES:

1. USE C3-8-2-F1 FIXTURE FOR DRILLING THE PIN HOLE.
2. REMOVE COIL SPRING BEFORE DRILLING HOLE.
- $\triangle 3$ TURN SHAFT AS SHOWN IN FIXTURE BEFORE DRILLING (CLOCKWISE).
4. INSTALL SPACER AND PIN IN PLACE AS SHOWN ON SHEET 1 AFTER DRILLING.

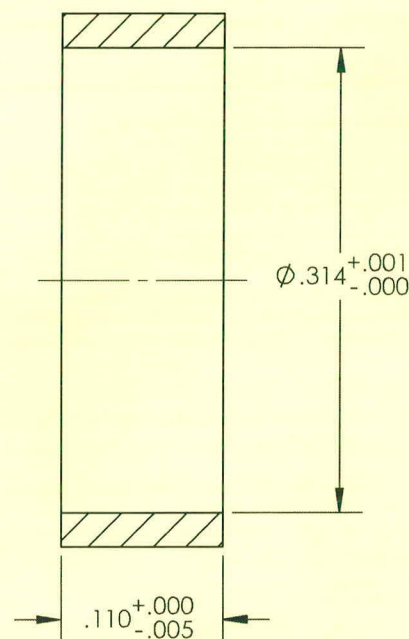
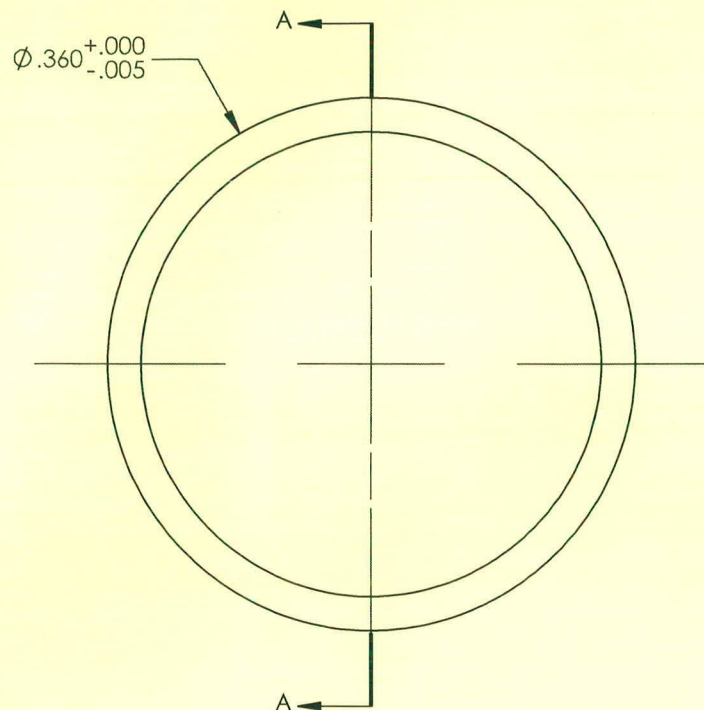
(C3-8-2-1)

SOLENOID WITH PINNED HOLE

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX $\pm .005$	HEAT TREAT
.XX $\pm .01$	FINISH
.X $\pm .1$	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE 12/19/2001
SHEET 2 OF 4	

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REVISIONS				DESCRIPTION	DATE	INITIAL	APPROVED
REV	ECR						



SECTION A-A

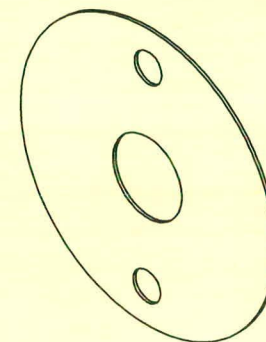
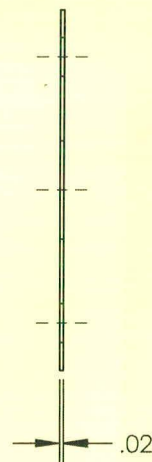
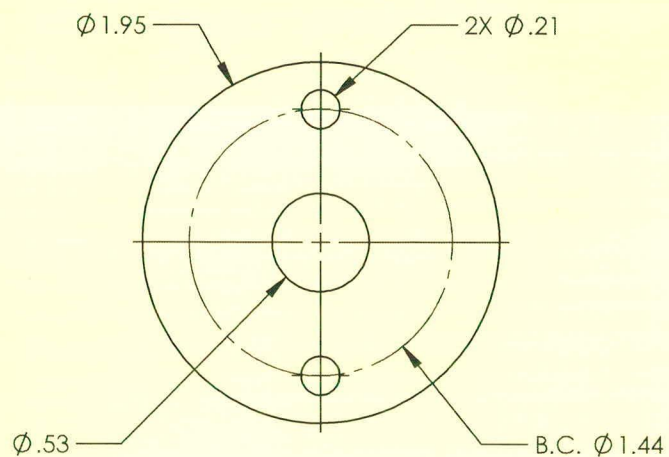
C3-8-2-2

SPACER

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L 303 S.S.	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/8	HEAT
.XX ± .01 ANGLES ± 5°	TREAT
.X ± .1	FINISH
1. BREAK ALL SHARP EDGES .015 x 45°	SPEC
OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 8:1	DATE 10/31/2001
SHEET 3 OF 4	

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1		ADDED SPACER C-3-8-3-1	10/10/2012	RJC	DW
2	14-0195	C3-8-3-1 CH'D DIM WAS Ø2.285 IS Ø1.95.	10/23/2014	DPD	JAG



C3-8-3-1

SPACER

DART AEROSPACE	
TITLE SOLENOID ASSEMBLY	
DWG NO. C3-8-2	REV 3
MAT'L PETG	DRAWN BY:
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
.XXX ± .010	FRACTIONS ± 1/8
.XX ± .03	ANGLES ± 5°
.X ± .1	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:1	DATE
SHEET 4 OF 4	



Container No: S104175



Part: C3-8-3-1

Job No: 179132

Serial No/Batch: S104175

Revision: 3

Inspector:

Exp Date:

Instructions:

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www.dartaerospace.com

Date: 08/22/16